

Tuesday, July 25, 2017 7:54:43 AM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

Start Date: 7/25/2017 **Start Qty:** 4.00

Required Date: 8/4/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: DAS Date: _____ Tooling: _____ Date: _____
QC: 21 Date: 11/17/2017 SPC (Y/N): _____ Date: _____
0.80

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4695 B

0.10

100

100

FLOW WATER JET

Waterjet

Memo

0.51

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: **B**

Prog Rev: 8

2-Debur if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.04

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.08

Quality Control

Work Order ID 164620

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164620

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Item ID: D4695-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Channel
Start Date: 7/25/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.29 0.70			DAS 30 9-89	(4)			SEP 08 2017
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				4	Ø		DAS 9 9-89 SEP 11 2017 DAS 19 9-89
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.40				(4)	Ø		2017-09-11 JSL DAS 24 9-89

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Item ID: D4695-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Channel
Start Date: 7/25/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.04				4	6	SEP 12 2017	DAS 19 9-89
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>5440</u> Memo stk in MF	0.00 0.04				4	6	SEP 14 2017	DAS 6 9-89
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.40						17/9/189	DAS 21 9-89 SEP 14 2017

Picklist Print

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Work Order ID: 164620

164620

Parent Item: D4695-3

D4695-3

Parent Item Name: Channel

Start Date: 7/25/2017

Required Date: 8/4/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12-07-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	77.2500	0.9	3.789474			DAS
M6061T6S 040									**			17/08/15	40
6061-T6 .040 Sheet													9-89

Location

Loc Qty

Loc Code

MAT

9.2

m137165

9.2

MAT021

68.05

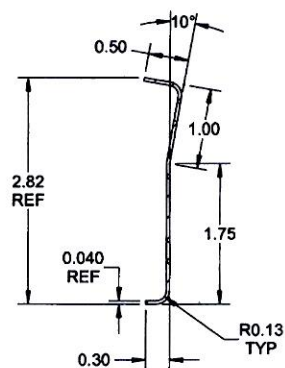
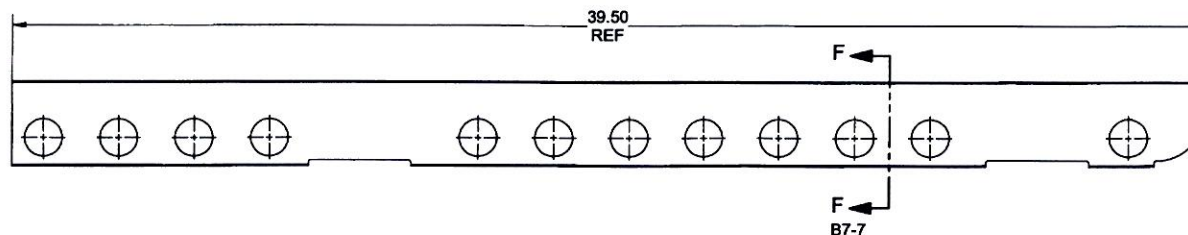
m137518

16.85

m137980

51.2

3.8



SECTION F-F C4-7

D4695-3 CHANNEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *164620 MJS*
1707-25

RELEASE
2013-04-02

NOTES:

- 1) MATERIAL: MAKE FROM D4695-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.44 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>BC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>2/</i>	D4695	SHEET 7 OF 12
APPROVED	<i>1/2</i>	TITLE	SCALE
DE APPR.	<i>SM</i>	CHANNEL ASSEMBLY	NTS
DATE	13.03.13	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

